

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015485**Date Inspected:** 06-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu tao / Li yan hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

FCAW welding of weld joint 1G-002 located on PCMK LD3036-001 for Lift 13 the welder is identified as 202122. ZPMC QC is identified as Mr. Lv Liqian. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-B-U2-F.

FCAW welding of weld joint 1G-001 located on PCMK LD3035-001 for Lift 13 the welder is identified as 202122. ZPMC QC is identified as Mr. Lv Liqian. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-B-U2-F.

This QA inspector performed 15% MT of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as OBG Side Plates for Lift 13. The weld designations reviewed as follows.

SP3060B-001-067,069,073,076,080,083. Green tag -13256.

SP3060F-001-053,055,059,061. Green tag-13255.

SP3092B-001-067,069,73,075,085. Green tag-13253.

SP3092E-001-011,025,018,028. Green tag-13252.

SP3060B-001-015,018,020,027,029. Green tag-13254.

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FCAW welding of weld joint 1G-126 located on PCMK SEG3006E for Segment 12CW the welder is identified as 202122. ZPMC QC is identified as Mr. Wang wei ming. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-B-U2-F.

SMAW welding of weld joint 4G-136 located on PCMK SEG3006G for Segment 12CW the welder is identified as 037840. ZPMC QC is identified as Mr. Wang wei ming. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-B-U2-FCM-1.

FCAW welding of weld joint 1G-230 located on PCMK SEG3006N for Segment 12CW the welder is identified as 201215. ZPMC QC is identified as Mr. Wang wei ming. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-Tc-U4b-F.

FCAW welding of weld joint 1G-006 located on PCMK SEG3006M for Segment 12AW the welder is identified as 047864. ZPMC QC is identified as Mr. Wang wei ming. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2231-B-U2-F.

BAY#16

SAW welding of weld joint 1G-002 located on PCMK BP3073-001 of Segment 13AW welder is identified as 450270. ZPMC QC is identified as Mr. Xin chun hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-U3c-S-2.

ZPMC personnel performing their UT of bottom plate splice weld is identified as BP3074-001-004 for segment 13AW.

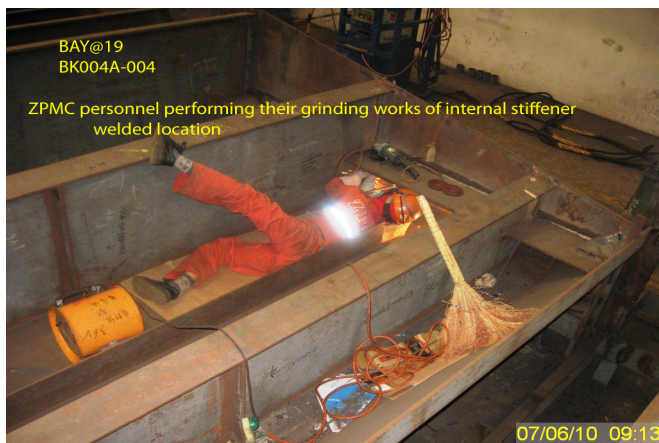
BAY#19

ZPMC personnel performing their grinding works on bike path BK004A-004 at PJP weld on internal diaphragm locations.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Chadra

Quality Assurance Inspector

Reviewed By: McClendon,Timothy

QA Reviewer